

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026462**Date Inspected:** 20-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Mai Quin Li**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Bike Path Hand Rails Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG Bay # 16

WELDING

This QA Inspector observed the following work in progress:

During random in process inspection this QA observed ZPMC personnel Heat Straightening Bike Path Handrail member as identified as BKR-FS2-063, between panel points PP83 & PP85. Heat Straightening is being performed to bring handrail into tolerance. ZPMNC Quality Control (QC) inspector identified as Mr. Mai Quin Li was present to monitor the heat straightening process. The heat straightening process did appear to comply with Heat Straightening Report HS # 10418 (B).

OBG Bay # 19

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of welds BK9003A5-001-100, located on Bike Path, BK9003A. Welder is identified as 062806. ZPMC Quality Control (QC) is identified as Mr. Zhang Qi Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

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## WELDING INSPECTION REPORT

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FCAW welding of welds BK9003A5-001-100, located on Bike Path, BK9003A. Welder is identified as 208632. ZPMC Quality Control (QC) is identified as Mr. Zhang Qi Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

FCAW welding of welds BK9003A5-001-100, located on Bike Path, BK9003A. Welder is identified as 062783. ZPMC Quality Control (QC) is identified as Mr. Zhang Qi Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

Bay #19

NDT

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 09943.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. Time of inspection was 14:00 hours. The members are identified as follows OBG Bike Path. The weld designations reviewed are as follow:

BK9003-A2-001-064, 062, 061, 059, 057, 078, 105, 115, 118, 125.

BK9003A8-001-061, 062, 063, 064

BK9003A9-001, 020, 021, 022

BK9003A8-001-025, 028, 032, 034, 037, 040, 044, 046

BK9003A5-001-116, 117, 166, 167, 135, 136, 187, 188, 154, 155, 200, 201, 118, 127, 175, 176, 137, 145, 189, 190, 156, 165, 202, 211

BK9003A6-001-058, 059, 090, 091, 078, 079, 242, 243, 060, 061, 092, 093, 080, 324, 244, 249

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

No relevant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Humphrey, Delbert

Quality Assurance Inspector

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**Reviewed By:** Hall, Steven

QA Reviewer